

Work Order ID 158966***158966***

Tuesday, April 04, 2017 12:47:55 PM

Item ID: D3769-3 **Accept** ***N900040100*** **Setup Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: Tube
Start Date: 4/5/2017 **Start Qty:** 6.00 ***6*** **Cust Item ID:**
Required Date: 4/10/2017 **Req'd Qty:** 6.00 ***6*** **Customer:**
Reference: scheduled

Approvals: **Process Plan:** DAS **Date:** APR 04 2017 **Tooling:** **Date:** **Run Start** ***NR1***
QC: 21 **Date:** **SPC (Y/N):** **Date:** **Stop** ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3769	Rev A								
100	Small Fab	0.00							
100									
Small Fab	Memo	0.60							
Small Fab	1-cut tube to length as per dwg D3769								
	2-drill holes thru on both ends of tube as per dwg D3769 using DT9411 Jig								
	3- deburr								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.12							
Quality Control									
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	0.26							
Hand Finishing									

APR 04 2017

DAS
38
9-89

APR 05 2017

201704/05
BE13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Work Order ID 158966

158966

Page 2

Tuesday, April 04, 2017 12:47:55 PM

Item ID: D3769-3 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Tube
Start Date: 4/5/2017 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 4/10/2017 Req'd Qty: 6.00 *6* Customer:
Reference: scheduled

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00							
130									
QC	Memo	0.06							DAS 38 9-89
Quality Control									APR 05 2017
140	Identify as per dwg & Stock Location: ST 254	0.00							
140									
Packaging	Memo	0.06							DAS 26 9-89
Packaging									APR 06 2017
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.60							17/4/10
Quality Control									DAS 21 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Tuesday, April 04, 2017 12:48:02 PM

Page 1

Work Order ID: 158966

158966

Parent Item: D3769-3

D3769-3

Parent Item Name: Tube

Start Date: 4/5/2017

Required Date: 4/10/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-06-18 rev.A as per dwg DD verified by:EC
IPP Rev:B 08-08-27 Drilling Tooling Added JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W065		Purchased			No	100	f	41.3418	1.265	7.989474			

M6061T6T1 000W065

6061T6 RD TUBE 1.00 x .065w

FP APR 04 2017

Location	Loc Qty	Loc Code
GA	35.212504	
M135565	10.672399	
M136760	0.540105	
M137169	24	
GA002	5.37684	
M136569	5.37684	
MAT	0.752413	
M132577	0.752413	

7.989474 NOT PULLED

DQA: _____ Date: _____

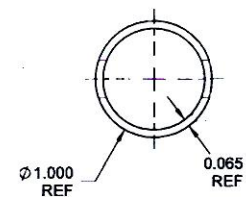
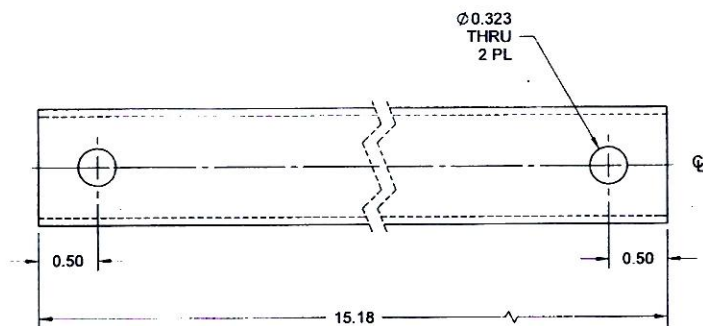


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Misidentified ☐	Past Due ☐								
		OTHER : _____							



D3769-3 TUBE

RELEASED
08.06.14/14

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3769	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TUBE	NTS
DATE	08.06.04	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL. NO DISSEMINATION OR REPRODUCTION IS PERMITTED WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	